

Date: Monday, 9/10/2007 10:03:20 AM  
 User: Chantal Lavoie











## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: BEARING ASSEMBLY
<b>Job Number</b>	: 34473		
<b>Estimate Number</b>	: 10716		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D3121241
<b>This Issue</b>	: 9/10/2007- S.O. No. : ..	<b>Drawing Number</b>	: D3121 REV D
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / / Type : MACHINED PARTS	<b>Drawing Revision</b>	: D
<b>Previous Run</b>	: 31760	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 9/10/2007 Qty: 6 Um: Each
<b>Checked &amp; Approved By</b>	:		
<b>Comment</b>	: Est Rev:A 04.02.18 New issue KJ/DS		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDELNR12500	DELIN ROUND BAR 1.25"
  <p>Comment: Qty.: 0.0546 f(s)/Unit Total: 0.3276 f(s)            Material: Ø1.25 Delrin Rod            (M-DELIN-R1.2500) Identify as D3121-25            Batch: _____</p> <p style="text-align: center;">N/A</p>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
  <p>Comment: HARDINGE CNC LATHE SMALL</p> <p>1-Turn D3121-25 Cap as per Folio FA387</p> <p>2-Deburr</p> <p style="text-align: center;">N/A Polled from stock. D3121-25 3251</p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
  <p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p style="text-align: center;">N/A</p>		
4.0	QC8	SECOND CHECK
  <p>Comment: SECOND CHECK</p> <p style="text-align: center;">N/A</p>		
5.0	D312123	Bearing
  <p>Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)            Pick:            Qty Part Number Description Batch            1 D3121-23 Bearing 5XB32170/1XB30520 c2</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/10/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 34473

Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

D3121-23 B 3 225902

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-09-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

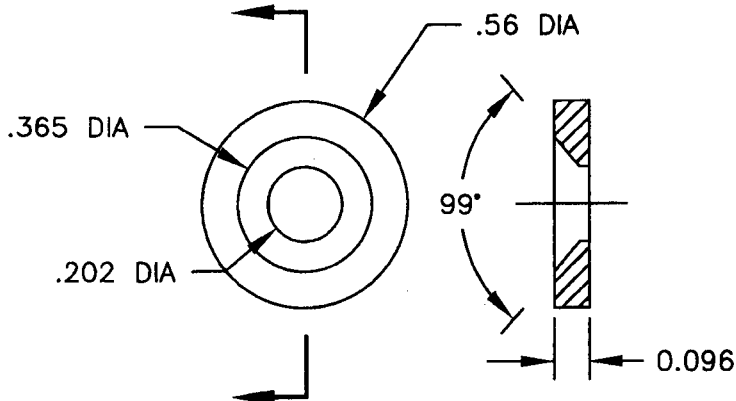
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/10	6.0	two parts (Bearing) Scrap Small parts in the inner seal. Due improper assembly human error	<i>[Signature]</i> D3142 D3142	Scrap and destroy and replace Bearing B4 B32170 CAP B4 B32251	<i>[Signature]</i> 07/09/10	<i>[Signature]</i> 07/09/10	<i>[Signature]</i> D3142	<i>[Signature]</i> D3142

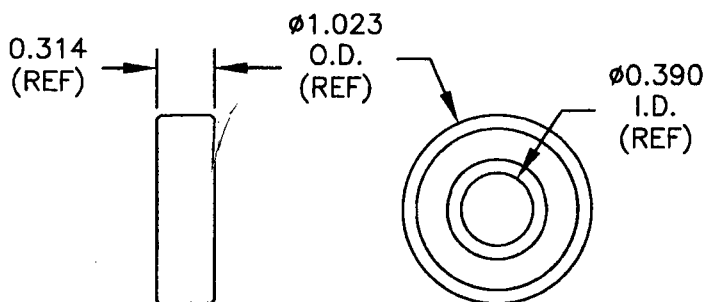
NOTE: Date & initial all entries

**DART**

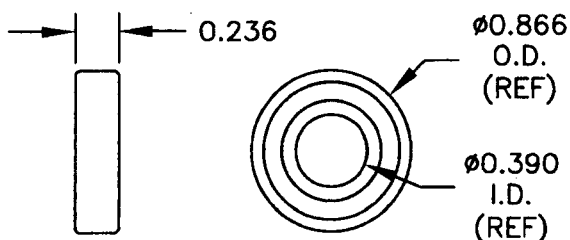
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D3121	REV. D SHEET 10 OF 10
DATE 06.05.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

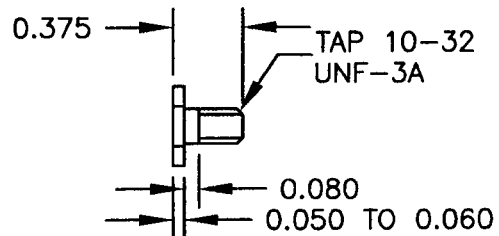
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

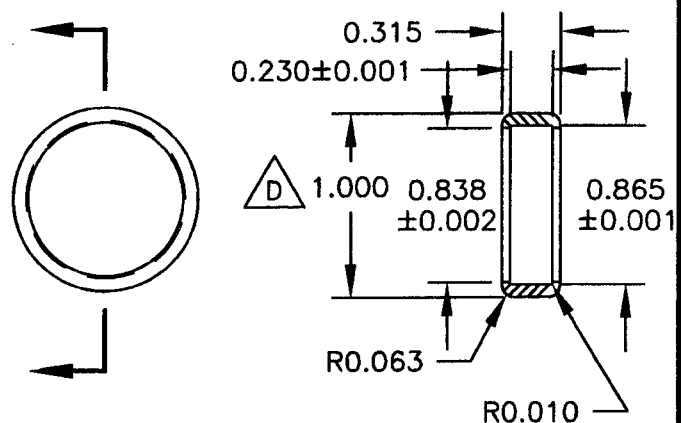
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

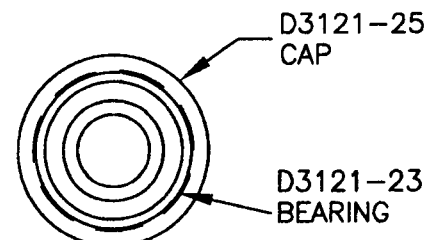
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

06-06-02

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)****Copyright © 2002 by DART AEROSPACE LTD**

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